

Date: Tuesday, 10/06/2008 12:54:22 PM  
 User: Julie Lecocq

## Process Sheet

|                                    |  |                           |                       |
|------------------------------------|--|---------------------------|-----------------------|
| <b>Customer</b> :                  | CU-DAR001 Dart Helicopters Services                | <b>Drawing Name</b> :     | 206 A/B HIGH GEAR WEB |
| <b>Job Number</b> :                | 39785  |                           |                       |
| <b>Estimate Number</b> :           | 10455  |                           |                       |
| <b>P.O. Number</b> :               |  | <b>Part Number</b> :      | D26543                |
| <b>This Issue</b> :                | 10/06/2008   | <b>S.O. No.</b> :         |                       |
| <b>Prsht Rev.</b> :                | NC   | <b>Drawing Number</b> :   | D2654 REV E1          |
| <b>First Issue</b> :               | 1/1  | <b>Project Number</b> :   | N/A                   |
| <b>Previous Run</b> :              | 38746  | <b>Drawing Revision</b> : | E1                    |
| <b>Written By</b> :                |  | <b>Material</b> :         |                       |
| <b>Checked &amp; Approved By</b> : | <u>JUD 08.6.10</u>                                 | <b>Due Date</b> :         | 16/06/2008            |
| <b>Comment</b> :                   | Est Rev:D 99.02.04 Fixed typo, Changed procedureDM |                           |                       |

Qty: 4 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D26005108 Extrusion 'I Beam' thin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

*X*

|     |             |             |                |
|-----|-------------|-------------|----------------|
| Qty | Part Number | Description | Batch          |
| 1   | D2600-5     | Web         | 20983 SL8-6-16 |

2.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2654

2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

*SL8-6-16*

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08/06/16 (X4)*

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*SL8-6-16*

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |  |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |  |    |      |     |                                     |                          |  |
|      |      |                    |  |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |           |                |                           |                       |                          |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 | Section B |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng |           | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Tuesday, 10/06/2008 12:54:22 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR WEB

Job Number: 39785

Part Number: D26543

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

(L) M 8-6-16

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: L6

SL 8-6-16

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/19 J

Job Completion



MF 08-06-17

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

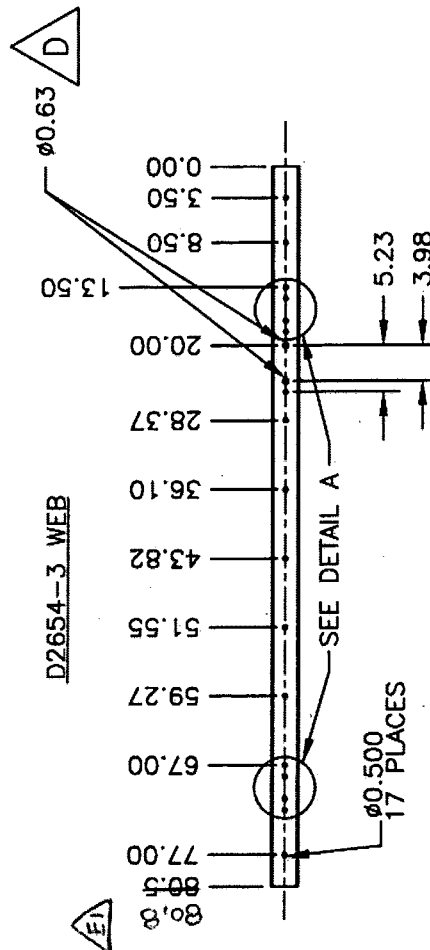
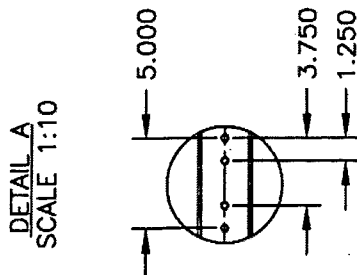
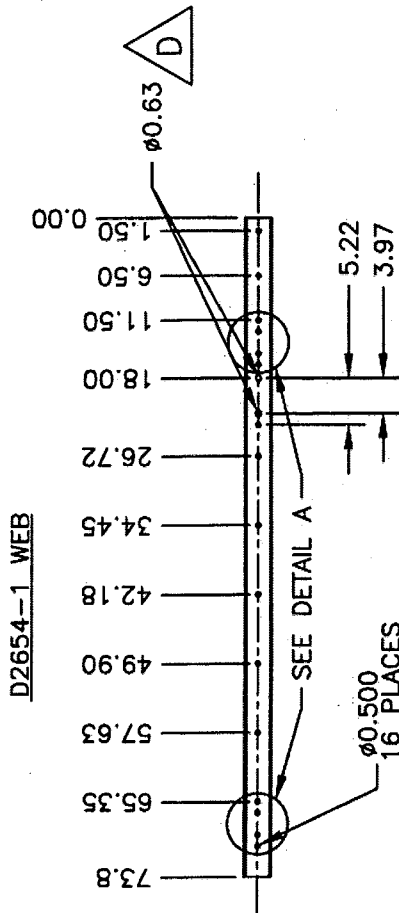
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |           |                |                           |                       |                          |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 | Section B |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng |           | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |

NOTE: Date & initial all entries



|                  |                    |                                    |  |  |  |
|------------------|--------------------|------------------------------------|--|--|--|
| DESIGN <i>CP</i> |                    | DRAWN BY <i>CP</i>                 |  | DART AEROSPACE USA, INC.<br>PORT HADLOCK, WA |  |
| CHECKED <i>#</i> |                    | APPROVED <i>#</i>                  |  | DRAWING NO. D2654<br>REV. E<br>SHEET 1 OF 2  |  |
| DATE<br>04.05.26 |                    | TITLE<br>WEB                       |  | SCALE<br>1:20                                |  |
| A                | 97.03.25           | NEW ISSUE                          |  |  |  |
| B                | 97.06.26           | ALTER HOLE PATRN., 0.500 WAS 0.438 |  |  |  |
| C                | 97.10.29           | CHANGED HOLE PATTERN               |  |  |  |
| D                | 98.01.15           | GHW HOLES CHANGED TO Ø0.63         |  |  |  |
| E                | 04.05.26           | CHANGE LENGTHS, REFORMAT           |  |  |  |
| E1               | <i>CP</i> 04.08.24 | PER TOOLING; 80.8 WAS 80.5         |  |  |  |

RELEASED  
04.06.22



MAKE FROM D2600-5-108 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39785

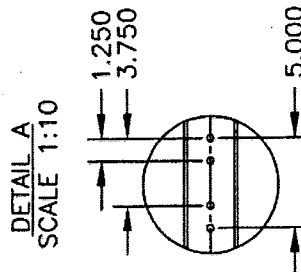
**Copyright © 1997 by DART AEROSPACE USA, INC.**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

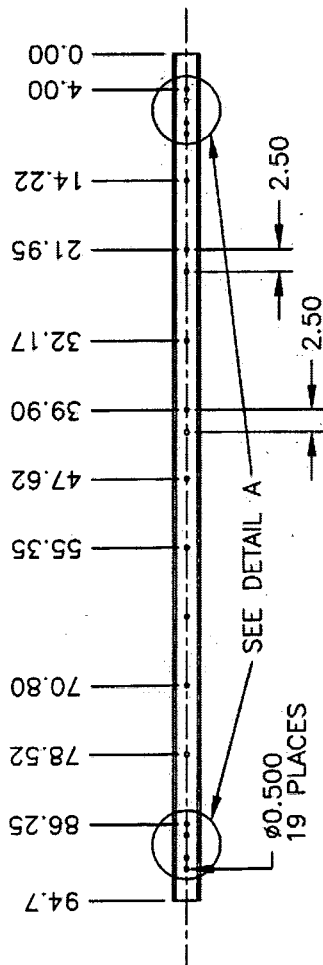


|                        |                         |  |                        |
|------------------------|-------------------------|--|------------------------|
| DESIGN<br>CP           | DRAWN BY<br>CP          | DART AEROSPACE USA, INC.<br>PORT HADLOCK, WA |                        |
| CHECKED<br>[Signature] | APPROVED<br>[Signature] | DRAWING NO.<br>D2654                         | REV. E<br>SHEET 2 OF 2 |
| DATE<br>04.05.26       |                         | TITLE<br>WEB                                 | SCALE<br>1:20          |

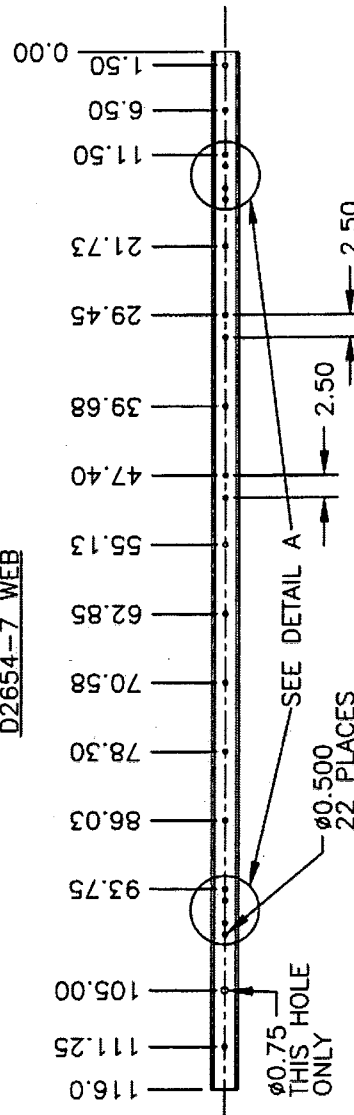
RELEASED  
04.06.22



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39785

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.